



Dart Aerospace Ltd.
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RBW109-3101-58-2-1
Job Sheet 169513



Part No: RBW109-3101-58-2-1

Job Qty: 1 ea

Part Name: Hammer, Aluminum



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 12/13/17

Job Tracking No:

Due Date: 12/15/17

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBW109-3101-58-2 Rev3 TEO17-641 IPP Rev A 17.12.12 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		12/14/17	0.00	0.00	Start Up Small Fab-4		MLL
100	Small Fab	1 pcs		12/15/17	0.00	1.00	Small Fab-9		MLL DAS
110	QC	1 pcs		12/15/17	0.00	0.00	QC5		38
130	Packaging	1 pcs		12/15/17	0.00	0.00	Packaging3-1		DAS 9-00
140	QC21-SA	1 Ea		12/15/17	0.00	0.00	QC21		MLL 21 JUL 26 2018

Part Op 100 - 1-Assemble as per DWG RBW109-3101-58-2 Sheet 2.2-Epoxy -5 shaft into -3 hammer head and -7 handle
Descriptions: -LOCTITE CLEAR EPOXY M 138676 EXP: 10/18 ***8hr. cure time*** Start time 2:00 pm End time 7:15 am 7/24/18
130 - IDENTIFY AND STOCK

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	102 RBW109-3101-58-2-3 5035173	1	0	0	0
	102 RBW109-3101-58-2-5 5032875	1	0	0	0
	RBW109-3101-58-2-7 -PO	1	0	0	0
5082521					

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

QA Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only ☐



Work Order: _____		DISPOSITION				AGAINST DEPARTMENT/PROCESS					
Part No. _____		Rework		Skid-tube		Cross tube		Water Jet		Engineering	
NCR No. _____		Scrap		Machining		Small Fab		Prod. Eng. Coord.		Quality	
		Use-as-is		Thermoforming		Finishing		Rec/Store/Packaging		Other	
		Suspected Unapproved		Large Fab		Composite		Supplier			
Date: _____	Step #: _____	QTY Effective: _____		Disposition				MRB (QS1042) Approval			
Description Work Order Deviation				Completed By							
Root Cause				C / QA Coordinator Approval							
				Lead hand / Supervisor Approval Verification							
Environment				situated Wrong							
Design				tside Dimensions							
Doc/Data				er/Under tolerance							
Equip/Tooling				t Incorrect							
Handling/Pre				: Lost/Missing							
Material				Moved							
Internal Transport				wing							
Tribal Knowledge											
LOA				Finish							
Substation				Misread							
Past Expiry Date				Turning Sequence							
Misidentified											
No Re-verification											
Operator											
Offset/Setup											
Supplier											
Training											
Use for Testing											
Poor Information											
Rushing											
Product Improvement											
Process Improvement											
Manufacturing Process											
Past Due											
OTHER: _____											

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Date: 07/23/18

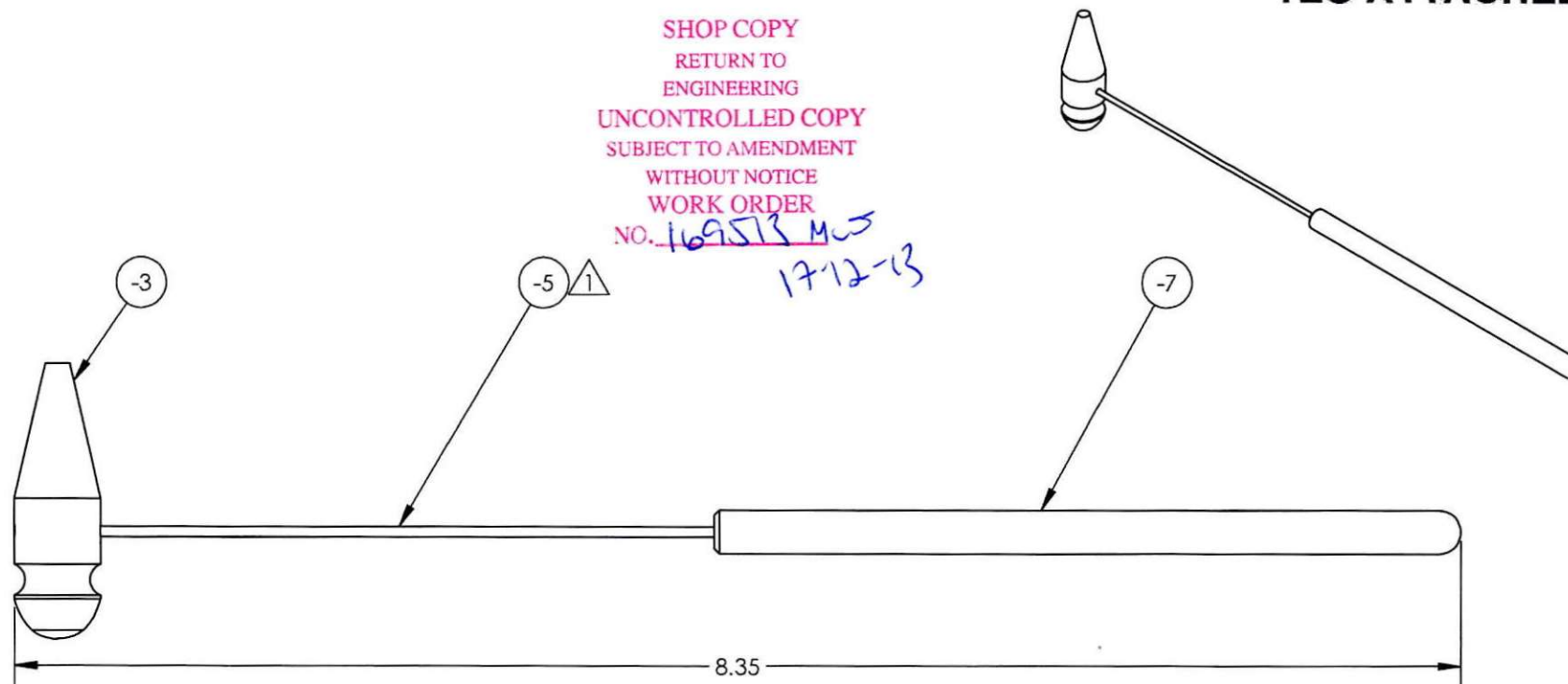
Customer No: 809274
Part: RDW109 - 6101-58-2-1
Job No: 169518
Serial No/Batch: 8095274
Revision: 3
Inspector:
Exp Date:
Instructions:

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0246	-1 CHD SHEET TOLERANCE WAS $\pm .005/\pm .01/\pm .1$ IS $\pm .010/\pm .03/\pm .1$.	12/2/2016	SM	JAG

TEO ATTACHED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 169513 MJS
1712-13



NOTES:

- ① EPOXY -5 SHAFT INTO -3 HAMMER HEAD & -7 HANDLE.

DART AEROSPACE	
TITLE HAMMER, ALUMINUM, BLADE CORROSION AND VOIDS DETECTION	
DWG NO. RBW109-3101-58-2-1	REV 3
MAT'L	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH	.XXX $\pm$.010 FRACTIONS $\pm$ 1/8
SPEC	.XX $\pm$.03 ANGLES $\pm$ 1°
	.X $\pm$.1 SURFACES = 125
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	AW109/AW119
SCALE 1:1	DATE 3/12/2015
SHEET 2 OF 5	

①
HAMMER, ALUMINUM



ENGINEERING ORDER # TEO17-641

SCALE: NTS

SHEET 1 OF 1

DRAWING NO. RBW109-3101-58-2

REV: 3

EFF.: NEXT ORDER

CHANGE CATEGORY

☐ MAJOR ☒ MINOR

DATE 17.09.07

TITLE: HAMMER, ALUMINIUM, BLADE CORROSION AND VOIDS DETECTION

APPROVED: WM 10/09/2017

MFG. APPR.: DP 09/27/2017

CHECKED: SAC 09/26/2017

DRAWN: VM 09/26/2017

TRANSACTION CODE (TC):

A-ADD C-CREATE
R-REVISE D-DELETE

REASON: EPOXY DETAILS MISSING

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USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION
FROM DART AEROSPACE LTD.

WAS : PART# RBW109-3101-58-2-1 CALLED : EPOXY (IN NOTES)
IS : PART# RBW109-3101-58-2-1 CALLED : ~~LOCTITE~~ CLEAR MULTIPURPOSE EPOXY

DP-460

mZa

JULY 23/18

DOCUMENTS EFFECTED: ☐ PATTERN ☐ INSTALL INSTRUCTIONS ☒ BOM